

Date: Monday, 1/7/2008 10:24:37 AM  
User: David Duval

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 36216  
Estimate Number : 10483  
P.O. Number :  
This Issue : 1/7/2008 S.O. No. :  
Prsht Rev. : NC  
First Issue : 12/10/2007 Type : MACHINED PARTS  
Previous Run : 33658  
Written By :  
Checked & Approved By :  
Comment : Est. A.05.09.01 New issue KJ/JLM

Drawing Name : TOW CAP  
Part Number : D3401041  
Drawing Number : D3401 REV B  
Project Number : N/A  
Drawing Revision : B  
Material :  
Due Date : 12/24/2007 Qty: 12 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M6061T6R3500 Inventory



Comment: Qty.: 0.3675 f(s)/Unit Total: 4.4100 f(s)

Inventory

Material: 6061-T6 Round Bar (QQ-A-225/8 or QQ-A-200/8)

(M6061T6R3.500)

Batch: 100720X8

M106534x19

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut Blanks

3.0 DOOSAN LATHE DOOSAN LATHE



Comment: DOOSAN LATHE

C LATHE LARGE

Turn as per Folio FA532 & Dwg D3401

Folio Rev: A

Dwg Rev: B

Deburr

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: Haas #1

Machine as per Folio FA532 and Dwg D3401

Dwg Rev: B

Folio Rev: B

Deburr & Buff rad as per Dwg D3401

Identify as D3401-1

DJP 08/03/11

72

1

2

3

4

5

6



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Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*mk 08/03/11*

*(5)*

7.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
Drill and c'sink using DT8782 as per Dwg D3401

*ff 08-03-11 (5)*

8.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

*08/03/11 (5)*

9.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1  
Chemical Conversion Coat as per QSI 005 4.1

*M-11*

*08/03/11*

*(5X)*

10.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING  
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*m/07005*

*FF 08/03/11 (5)*

11.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*08-05-12*

*(x5)*

12.0	NAS1330C3KB116	Insert
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 48.0000 Each(s)

Insert

Pick:

Qty	Part number	Description	Batch
-----	-------------	-------------	-------

4	NAS1330C3KB116 Insert		
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Assemble as per Dwg D3401

Identify as D3401-041

*M100712*

*08-03-12 (x5)*

2/2

closed

Billingsville

Billingsville

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Job Number: 36216

Part Number: D3401041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/2/12 (5)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-21

MD 08-05-12 (5)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(5)  
2008/03/12

Job Completion



2008/3/12 (5)

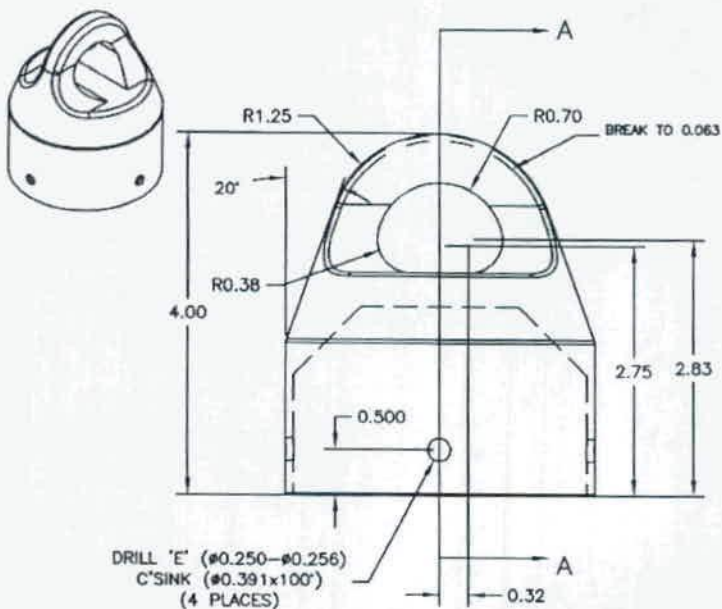




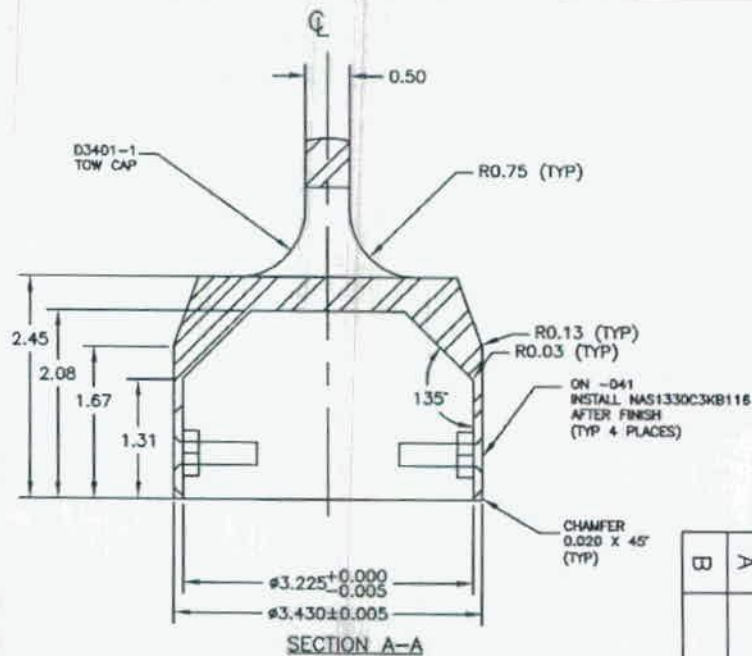






**DART**

D3401-1 TOW CAP



D3401-1/-041 TOW CAP

D3401-1 TOW CAP

- 1) MATERIAL: MAKE FROM ALUMINUM 6061-T6 Ø3.500 ROUND BAR  
PER QQ-A-225/8 OR AMS-QQ-A-200/8  
(REF. DART SPEC M6061T6R3.5000)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.015
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D3401-041 TOW CAP



- 1) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3

D3401-041 TOW CAP PARTS LIST

QTY	PART NUMBER	DESCRIPTION
1	D3401-1	TOW CAP
4	NAS1330C3KB116	INSERT

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
NOTICE

05-08-09

DESIGN	PH	DRAWN BY	PH	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
CHECKED		APPROVED		DRAWING NO.	REV. B
				D3401	SHEET 1 OF 1
DATE				TITLE	SCALE
05.06.09				TOW CAP	1:2
A				05.02.24	NEW ISSUE
B				05.06.09	CHAMFER INSIDE, REMOVE RADIUS

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